

Split
Work Order ID 61847-1

September 7, 2010 3:22:05 PM



Page 1

Item ID: D3439-101

Accept

Revision ID:

Item Name: Mirror Assembly 8"

26

70 C/L 10/9/13

Start Date: 9/07/10

Start Qty: 50.00



Required Date: 9/09/10

Req'd Qty: 50.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: CZ

Date: 10/9/17

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3439

Rev A B

100



Purchasing

PURCHASING

0.00

Memo

0.00

Issue P/O: 12524
For Grote Mirror P/N: 12183
Possible Supplier: UAP/NAPA
Material release note is required

110



Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

0.00

Ensure Material Release Note is attached

115.

→ 26 6 inspect parts

8/10/13

8/10/13

Counters

x70

Pto →

Pto
CZ 10/9/17 (50)

10/7/10 (70)

W/O: 61847-1		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
		Perm. changes.							
10/09/13	# 100	- Fix handle bar Dry now at "Rev B"					S 10/09/13		
10/09/13	# 115	ADD step for QC 6 inspection	A	10.09.23			S 10/09/13		

Part No: D3439-101 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)								
NCR:								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

Initial all entries

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Cust Item ID:

Required Date: 9/09/10 Req'd Qty: 50.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



Small Fab

Small Fab

Small Fab

Memo

Discard Hardware.

Fabricate stud as per Dwg D3439

Pick:

Qty Part Number Description Batch

1 5/16"-18UNCx1 1/2" Long Hex Bolt

Drill and Tap mirror as per Dwg D3439, then install stud.

Coat threaded section of stud with LPS-3

W 20 ECR 10.607

Discard Hardware

2-Drill + Tap mirror as per dwg

D3439, then install stud D3439-3

26X

m-l 10/09/21

130,



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

N/A

10.09.17

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Required Date: 9/09/10 Req'd Qty: 50.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



Small Fab

Small Fab

0.00

Memo

0.00

Plug drain holes with Sikaflex.
Ensure that mirror adheres to housing.
Pick:Qty Part Number Description Batch
A/RN/A Sikaflex-241/-291
Sikaflex expiry date 01/2011

M115114 / m-l 10/09/21

(26X)

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8/10/22

(26X)

160



Packaging

Packaging

Identify as per dwg & Stock Location: 228

0.00

Memo

0.00

10/9/22 S/D 26X

Order ID 61847



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Item Name: Mirror Assembly 8"

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Cust Item ID:

Required Date: 9/09/10 Req'd Qty: 50.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/23
MF
10-9-22

2010 3:22:04 PM

Work Order ID: 61847

Parent Item: D3439-101

Parent Item Name: Mirror Assembly 8"



Start Date: 9/07/10

Required Date: 9/09/10

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP A 05.07.20 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
12183 GROTE MIRROR		Purchased	No			120	Each	0.0000	1	50	26x	m-l w/09/21	
5/16WC SS Flat Washer 5/16		Purchased	No			120	Each	1,995.000	1	50		m-l w/09/20	

Location	Loc Qty	Loc Code
ST377	1995	
112560	176	
114758	77	
115072	949	
115110	293	
115174 ✓	500	

D3015-3

Locknut

Manufactured No

120 Each 582.0000 1

Location	Loc Qty	Loc Code
ST033	582	
43758	26	
56701	3	
58202 ✓	70	
60287	483	

D3439-3
per EON 10-607

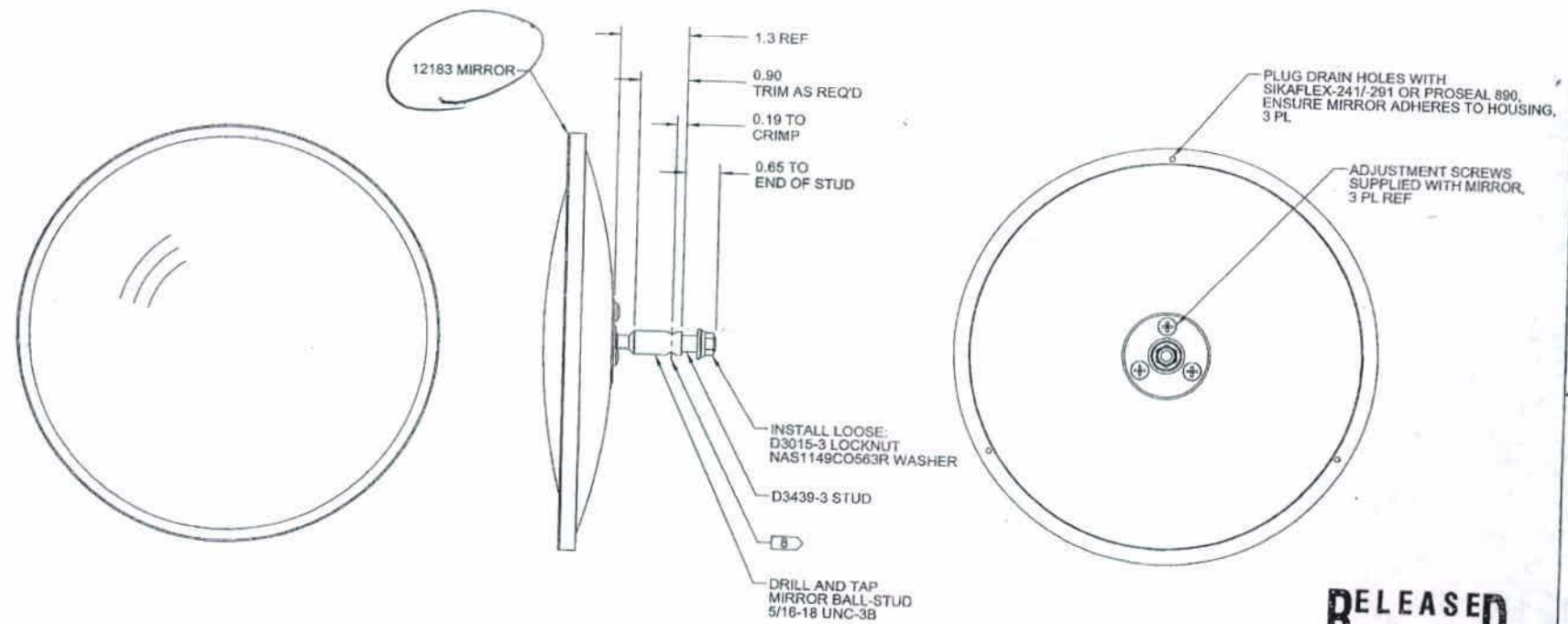
1 each

8 61866 26x
m-l w/09/20

435

02101917
W10.

ITEM	QTY	P/N	DESCRIPTION
1	X	D3439-101	MIRROR ASSEMBLY, 8"
2	1	12183	MIRROR 8" (GROTE)
3	1	D3015-3	LOCKNUT
4	1	D3439-3	STUD
5	1	NAS1149CO563R	WASHER (OR AN960JD516)



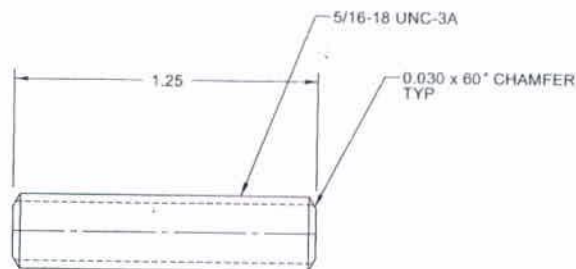
D3439-101 MIRROR ASSEMBLY


NOTES:

- 1) MATERIAL: MIRROR= 8" ROUND CONVEX MIRROR W/ STAINLESS STEEL CASE
CENTER-MOUNT BALL-STUD W/ 1/4-20 X 1" DEEP FEMALE THREAD
GROTE INDUSTRIES, 2600 LANIER DRIVE, MADISON, INDIANA 47250
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3439-101" USING REMOVEABLE TAG
- 7) WEIGHT: 1.18 lbs
- 8) TO INSTALL D3439-3 STUD:
 - APPLY LOCKTITE 262 TO THREADS BEING INSTALLED INTO MIRROR BALL-STUD
 - THREAD D3439-3 STUD INTO MIRROR BALL-STUD
 - CRIMP MIRROR BALL-STUD ON OPPOSING SIDES, 0.19 FROM END AS ILLUSTRATED USING TOOL DT8317
 - CRIMP TO DEPTH OF 0.015-0.030 USING R0.125

RELEASED
2010-09-07

B	REDRAW, ADD -3 (WAS PURCHASED/TRIMMED BOLT), RMV LPS	CP	10.07.20
A	NEW ISSUE	CP	05.05.27
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. B
CHECKED		D3439	SHEET 1 OF 2
MFG. APPR.		TITLE	SCALE
APPROVED		MIRROR ASSEMBLY	NTS
DE APPR.		DATE 10.07.20	
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D3439-3 STUD 

NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR PER ASTM A582
REF DART SPEC M303R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs

RELEASED
2010-09-07
MP

DESIGN	<i>JP</i>	DART AEROSPACE LTD	
DRAWN	<i>JP</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JP</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>JP</i>	D3439	SHEET 2 OF 2
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	MIRROR ASSEMBLY	NTS
DATE	10.07.20	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO12524

Purchase Order Date 9/07/10

PO Print Date 9/08/10

Page Number 1 of 1

Order From : VC-UAP001

UAP HAWKESBURY INC. #074
514 MAIN STREET WEST
HAWKESBURY, ON K6A 2J2
CA

REVISED

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	613 632 8575	Requisition Nbr	
Vendor Fax	613 632 1539	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED
09/19/10

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
12183		GROTE MIRROR	9/09/10 Yes	70.00 Each	Yours ppd	\$20.9000	\$1,463.00

Special Inst: AS PER DWG D3439 REV. A
B61847
GROTE MIRROR P/N: 12183

PO Total: \$1,463.00

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

Change Nbr: 2

Change Date: 9/08/10

W CZ
No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



DANGEROUS GOODS PERMIT
EXPIRY DATE:
PERMIS RELATIF AUX MARCHANDISES DANGEREUSES.
DATE D'EXPIRATION:

EMERGENCY TELEPHONE NUMBER 24 HOURS
CANUTEC 613-996-6666
NUMÉRO DE TÉLÉPHONE D'URGENCE 24 HEURES
CANUTEC 613-996-6666

ACCT # N° COMPTE	SOLD TO / VENDU À	DATE	TIME HEURE	STORE # N° MAGASIN	EMP # N° EEMPL	INVOICE NO. N° FACTURE
		PURCHASE ORDER # N° BON DE COMMANDE				ATTENTION
SR #		TAX EXEMPTION: EXEMPTION DE TAXE:				
		TERMS: CONDITIONS:				
AD		DELIVERY: LIVRAISON:				
PART NUMBER / N° PIÈCE	LN	DESCRIPTION	QUANTITY QUANTITE	PRICE / PRIX	NET	TOTAL
12183			450.00			
12183			600.00			
In arrears		S. 10/04/13				

S. Willemes

SIGNATURE

ALL GOODS RETURNED MUST BE ACCOMPANIED BY THIS INVOICE
TOUTE MARCHANDISE RETOURNÉE DOIT ÊTRE ACCOMPAGNÉE DE CETTE FACTURE